

Work Order ID 114294-2 *SPUT****114294***

Page 1

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Item ID: D4012-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cushion

Start Date: 04/03/2014 Start Qty: 24.00

24

Cust Item ID:

Required Date: 04/03/2014 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals:

Process Plan: *WA*Date: *14-03-05*

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4012

B

10G

0.00

100

Mill Conv

Memo

0.00

Conventional Milling Machine

DT9889

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

*DI 14-04-05**25**0**MH**14/05/03**DI 14-04-05**25**0**MH**14/04/03**25**0**14/04/05*

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Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

123

123

Small Fab

Small Fab

Memo

CLAMP AND FORM CUSHION AS PER DWG BY SLIGHTLY HEATING IT WITH HEAT GUN, LET IT COOL DOWN BEFORE REMOVING CLAMP.

0.00

0.00

18

FF
14-05-06

126

126

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

DAS

27

9-89

14/5/7

18

130

130

Packaging

Packaging

Identify as per dwg & Stock Location: SI450

Memo

0.00

0.00

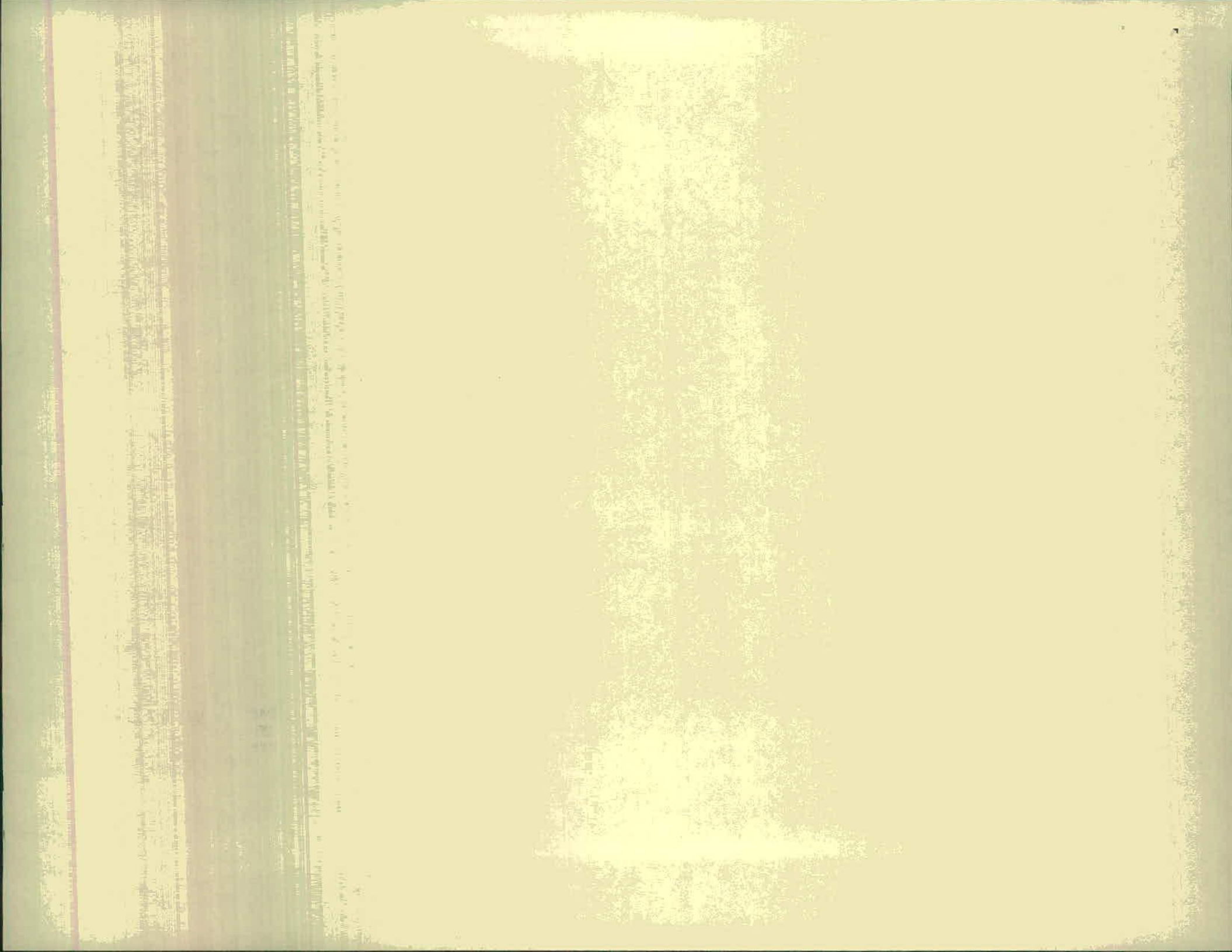
18x

DAS

28

9-89

MAY 07 2014



Work Order ID 114294

March-04-14 3:00:42 PM

114294

Page 3

Item ID: D4012-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Cushion

Stop ***NS2***

Start Date: 04/03/2014 Start Qty: 24.00

24

Cust Item ID:

Required Date: 04/03/2014 Req'd Qty: 24.00

24

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

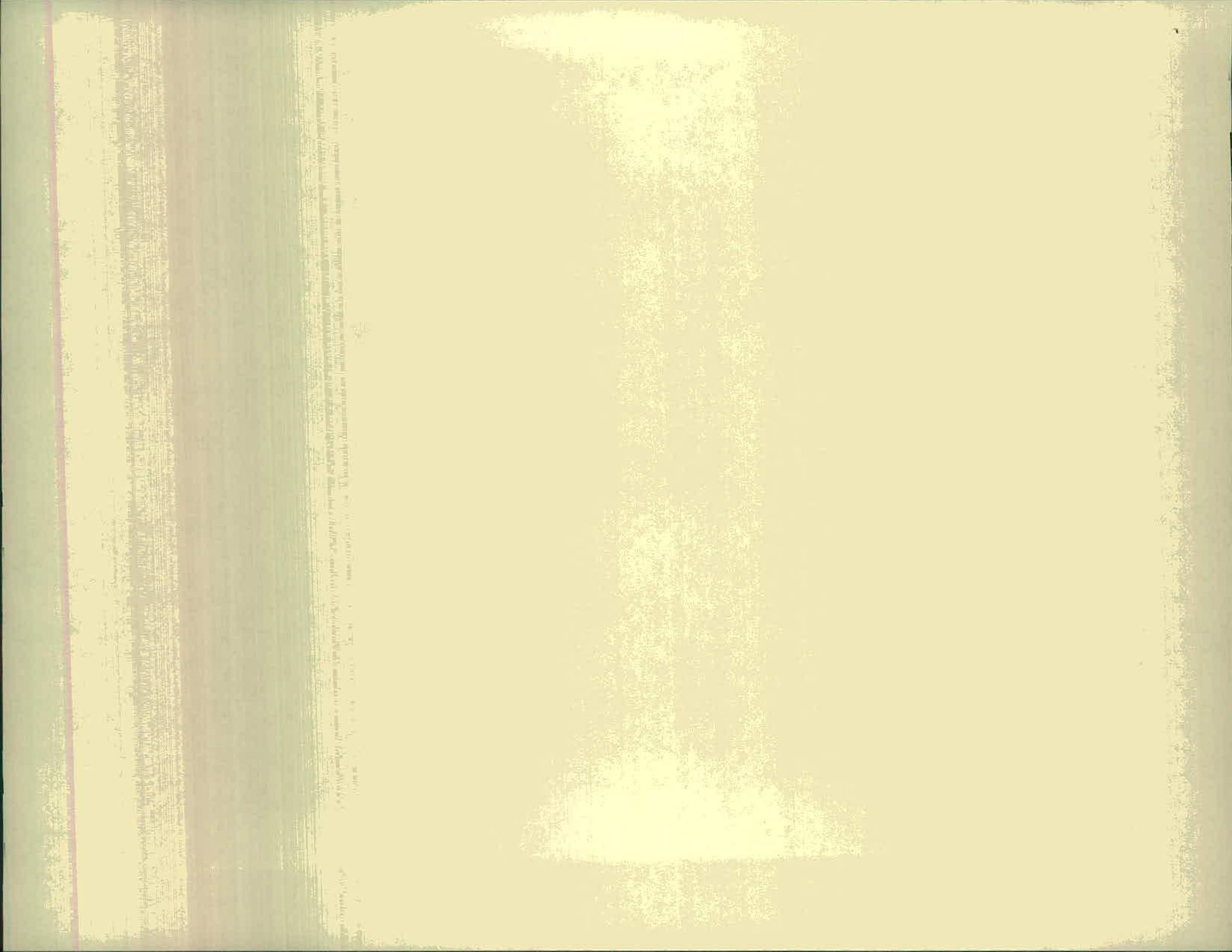
Memo

0.00

Quality Control

MLJ 140508

JH 140508



Picklist Print

March-04-14 3:00:42 PM

Page 1

Work Order ID: 114294

114294

Parent Item: D4012-1

D4012-1

Parent Item Name: Cushion

Start Date: 04/03/2014

Required Date: 04/03/2014

Start Qty: 24.00

Required Qty: 24.00

Comments:

IPP RevA: New issue 09.10.28 DD verified by:JLM
revA as per dwg 09.11.18 DD verified by:JLM
as per dwg Rev.B DD verified by:JLM

IPP RevB:
IPP Rev:C 11.01.10

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-3		Manufactured	No			100	f	28.0000	0.37	10			

D4287-3

Ultraw U-Channel

**

Location

Loc Qty

Loc Code

MAT039

12

ST209a

12

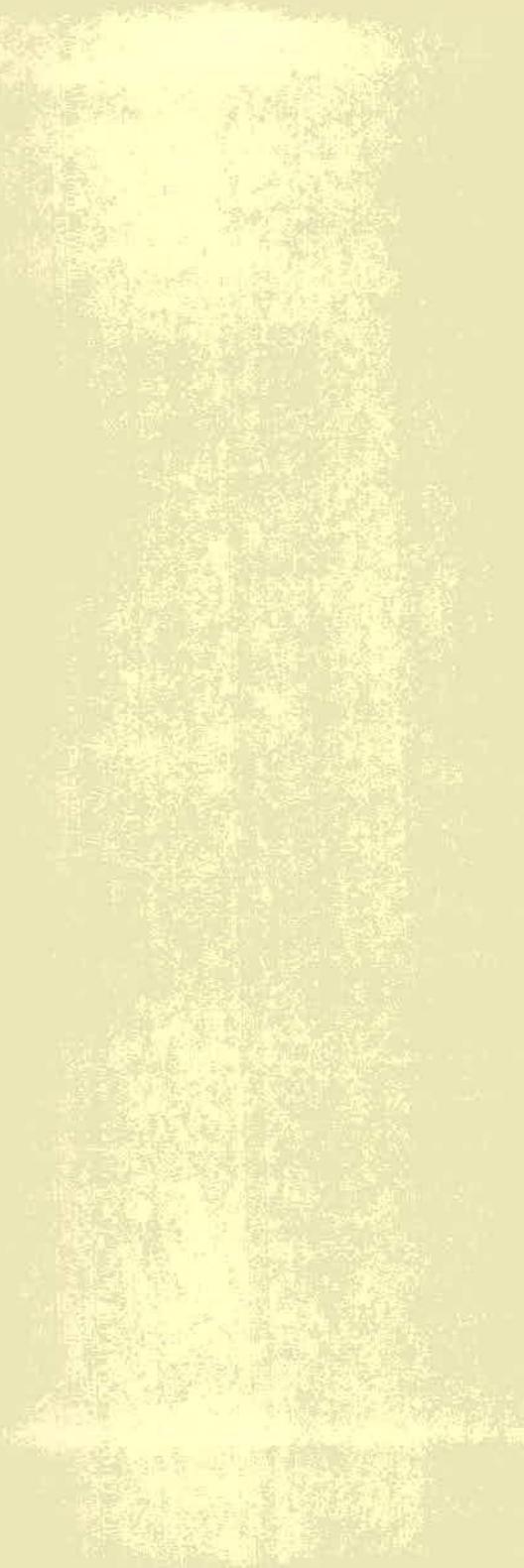
16

4

113570

16

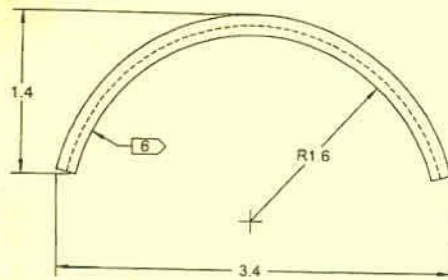
9.5 JFL 2014-04-02



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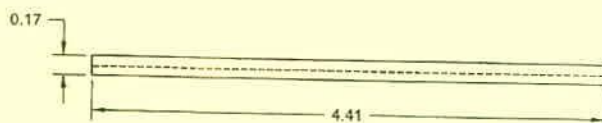
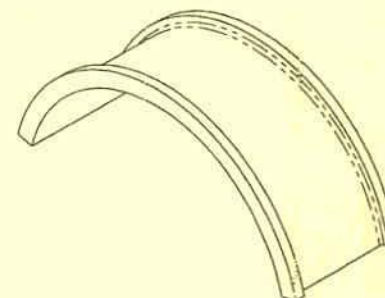
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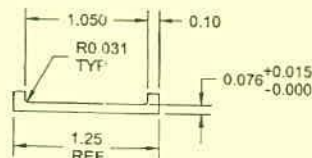


D4012-1 CUSHION
 (MAKE FROM D4012-1F)

114294 MP
 1403-05



D4012-1F FLAT MACHINED STATE



RELEASED
 2010-12-23

NOTES:

- 1) MATERIAL: MAKE FROM D4287-3
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4012-1" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs

B	CHANGED RAW MATERIAL TO REDUCE MANUFACTURING COSTS. PART NOW MACHINED FLAT AND SHAPED WITH RADIUS. REF: PART-29	MM	10.12.07
A	NEW ISSUE	MM	09.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG APPR.			
APPROVED			
DE APPR.			
DATE	10.12.07		

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4012**
 TITLE **CUSHION**
 REV. B
 SHEET 1 OF 1
 SCALE
 NTS

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